

Date: Monday, 28/04/2008 8:13:27 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: WEAR PLATE		
Job Number	: 38811			Part Number	: D2348		
Estimate Number	: 11231			Drawing Number	: D2348 REV B2		
P.O. Number	:			Project Number	: N/A		
This Issue	: 28/04/2008	S.O. No.	:	Drawing Revision	: B2		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: SMALL /MED FAB	Due Date	: 15/05/2008		
Previous Run	: 31919			Qty:	50 Um: Each		
Written By	:			S. Lecocq			
Checked & Approved By	: <u>JUL</u> 08.4.28						
Comment	Est Rev A	Removed from 9 Digit 05-12-05 JLM					
	Est Rev:B	Now on Waterjet 06-07-03 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
1.0	M6061T6S063	6061-T6 .063 Sheet
		 Comment: Qty.: 0.0208 sf(s)/Unit Total : 1.0395 sf(s) Material: 6061-T6 (QQ-A-250/11) 0.063" thick (M6061T6S.063) Batch: <u>105285</u> <u>IR 8-4-30</u>
2.0	WATER JET	FLOW WATER JET
		 Comment: FLOW WATER JET 1-Cut as per Dwg D2348 Dwg Rev: <u>B2</u> <u>IR 8-4-30</u> Prog Rev: <u>B2</u>
		 Comment: 2-Deburr if necessary <u>IR 8-4-30</u>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		 <u>IR 8-4-30</u> Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>IR 8-4-30</u>
4.0	QC8	SECOND CHECK
		 <u>IR 8-4-30</u> Comment: SECOND CHECK <u>IR 8-4-30</u>
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		 Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr <u>IR 8-4-30</u>
		<u>IR 8-4-30</u> <u>IR 8-4-30</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Sodostar *pass* *coaster*

Comment: INSPECT WORK TO CURRENT STEP

7.0 OUTSIDE SERV.20

OUTSIDE SERVICE - SF



Comment: Sub-Contracting PURCHASING

Issue P/O: _____

Black Anodize per Dwg D2348

Ensure Certificate of Conformity is attached

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

9.0 QC5

INSPECT WORK TO CURRENT STEP



Scrap



Comment: INSPECT WORK TO CURRENT STEP

INSPECT CERTS

10.0 FE832EF

PEM Insert



Comment: Qty.: 4.0000 Each(s)/Unit Total: 200.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 FE832EF

PEM Insert

101634 *22X*

107897 *X198* *107897* *XX*

11.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install Insert as per Dwg D2348

Bos/05/20

55

910

12.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2348 PAR #: N/A Fault Category: Prod/Finishing NCR: Yes No DQA: DS Date: 29/05/29
QA: N/C Closed: DS Date: 28/05/29

NCR: 38811		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/05/22	11.0	Inserts were pressed into the parts, and the parts were not anodized. Steps 7.0, 8.0 & 9.0 were not completed. R.C: Employee continued with the parts, when previous steps of work was not completed, lack of attention to the process.	DS1012	<ul style="list-style-type: none"> - Scrap & destroy all parts. - no replace. - Ensure to double check W.O for completeness before starting a step, and continuing the process. 	JP 08/05/29 08/05/29	SB 08/05/29	DS1012	08/05/22

NOTE: Date & initial all entries

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Job Number:



Seq. #: Machine Or Operation:

Description :

13.0 PACKAGING 1



PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

14.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-05-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	38811
Description: Wear Plate	Part Number:	D2348
Inspection Dwg: D2348	Rev: B2	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: <u>B</u>	Audited by:	Prototype Approval:	N/A
Date: <u>8-4-23</u>	Date:	Date:	N/A

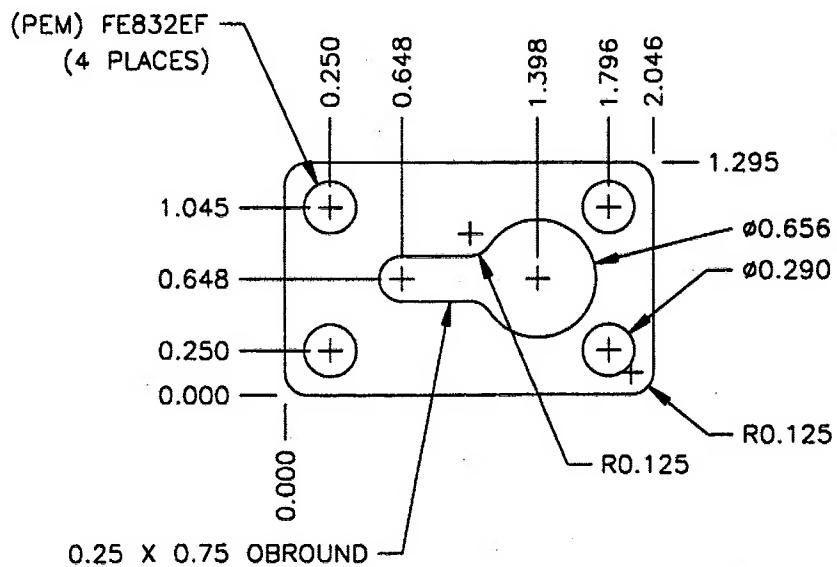
Rev	Date	Change	Revised by	Approved
A	04.06.25	New Issue	P/O D350-616-015	KJ/JLM <i>[Signature]</i> <i>[Signature]</i>



DESIGN B. WILLIAMS	DRAWN BY B. WILLIAMS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA		
CHECKED <i>D.W.</i>	APPROVED <i>D.W.</i>	DRAWING NO. D2348	REV. B SHEET 1 OF 1	
DATE 95:01:20		TITLE WEAR PLATE	SCALE 1:1	
B	95:02:20	CHANGED PEM INSERT TO 8-32		
BI	00.03.07	CHANGE TO AISI 304/316 MATERIAL		
B2	RF 02.02.21	CHANGE BACK TO 6061-T6		

RELEASED
97/04/22 DS

97/04/22 DS



NOTES: 1) MATERIAL: 6061-T6 ALUMINUM SHEET 0.063 THICK PER QQ-A-250/11 (M6061T6S)
2) FINISH: BLACK ANODIZE PER MIL-A-8625F TYPE I/II/IC/II/IB CLASS 2.
3) INSTALL FE832 EF INSERTS AFTER ANODIZING
4) ALL DIMENSIONS ARE IN INCHES
5) TOLERANCES ARE PER PART QSF 018 UNLESS OTHERWISE NOTED.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 58811

~~AISI 304/316 SS~~

MATERIAL: ~~6061-T6 ALUMINUM 0.063 THICK, ANODIZE BLACK
AFTER ANODIZING INSTALL (PEM FE832EF) 4 PLACES~~